



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4271-025**  
**Job Sheet 180383**



Part No: D4271-025

Job Qty: 1 ea

Part Name: End Fitting Assembly Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No: GLOSS BLACK

Due Date: 7/10/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 2 IPP revA 11.07.20 new issue EC verified by:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 1 Ea  | 7/10/18    | 7/10/18  | 0.00      | 0.00    | Start Up Small Fab-3  | 8:00      | JUL 12 2018 |
| 100   | Small Fab          | 1 pcs | 7/10/18    | 7/10/18  | 0.00      | 0.49    | Small Fab-6           | 8:00      | DAS 38      |
| 110   | QC                 | 1 pcs | 7/10/18    | 7/10/18  | 0.00      | 0.00    | QC5                   | 8:00      | DAS 38      |
| 120   | Packaging          | 1 pcs | 7/10/18    | 7/10/18  | 0.00      | 0.00    | Packaging3-2          | 5:37:06   | JUL 16 2018 |
| 130   | QC21-SA            | 1 Ea  | 7/10/18    | 7/10/18  | 0.00      | 0.00    | QC21                  | 9:89      | DAS 53      |

### Job BOM

| Part / Item   | Component Name    | Quantity      | Operation             | Container |
|---------------|-------------------|---------------|-----------------------|-----------|
| AN4C13A       | Bolt              | 2 Ea (2 ea)   | 90-Start up Operation | 5067894   |
| D4149-5       | Eyebolt Stud      | 1 Ea (1 ea)   | 90-Start up Operation | 5088071   |
| D4281-1       | Spacer            | 1 Ea (1 ea)   | 90-Start up Operation | 5090747   |
| D4281-3       | Spacer            | 1 Ea (1 ea)   | 90-Start up Operation | 5090742   |
| D4419-1       | Fwd Support Plate | 2 Ea (2 ea)   | 90-Start up Operation | 5075828   |
| MS20427M4-20  | Rivet             | 1 pcs (1 ea)  | 90-Start up Operation | F118428   |
| MS20615-4M18  | Rivet             | 10 Ea (10 ea) | 90-Start up Operation | 5083520   |
| MS21043-4     | Nut               | 2 Ea (2 ea)   | 90-Start up Operation | 5062296   |
| NAS1149C0432R | Washer            | 4 Ea (4 ea)   | 90-Start up Operation | 5052032   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | AN4C13A        | 2        | 63        | 0         |
|                       | D4149-5        | 1        | 6         | 0         |
|                       | D4281-1        | 1        | 1         | 0         |
|                       | D4281-3        | 1        | 30        | 0         |
|                       | D4419-1        | 2        | 2         | 0         |
|                       | MS20427M4-20   | 1        | 28        | 0         |
|                       | MS20615-4M18   | 10       | 62        | 0         |
|                       | MS21043-4      | 2        | 812       | 0         |
|                       | NAS1149C0432R  | 4        | 1,617     | 0         |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| Work Order: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                  | <b>AGAINST DEPARTMENT/PROCESS</b>                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                     | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Thermoforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                    | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Composite <input type="checkbox"/>                                                                                                                                                                                                                                                                                                             | Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                   | Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                        |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | # : _____                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                                                                                                                                                                                                                                             | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                         | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                             |
| der Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                     | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                      |
| <div style="float: left; width: 40%;"> <p style="font-size: small;">Dart Aerospace Ltd.<br/>1270 Aberdeen Street<br/>Chatham, ON K84 1K7<br/>CANADA<br/>TEL: 1 813 632-5200<br/>Email: sales@dartaero.com<br/>www.dartaerospace.com</p> </div> <div style="float: right; width: 60%;"> <p style="text-align: right;">Date: 07/12/18</p> </div> <div style="clear: both;"></div> <div style="text-align: center;"> <p><b>Container No: S091199</b></p> <p><b>Part: D4271 - 025</b></p> <p><b>Job No: 180383</b></p> <p><b>Serial No/Batch: S091199</b></p> <p>Revision: _____</p> <p>Inspector: _____</p> <p>Exp Date: _____</p> <p>Instructions: _____</p> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                                      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                                      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environm _____<br>Des _____<br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/>                                                                                                                                                                                                                | Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |



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## Container View (Active) - Master Unit Containers

| Master Unit No | Container No | Part No       | Part Name         | From Container | Current Location | Quantity |
|----------------|--------------|---------------|-------------------|----------------|------------------|----------|
| 004352         | S091198      | AN4C13A       | Bolt              | s067894        | ST344            | 2        |
| 004352         | S088524      | D4149-5       | Eyebolt Stud      | S088523        | ST081            | 1        |
| 004352         | S090744      | D4281-1       | Spacer            | S090743        | ST084            | 1        |
| 004352         | S090742      | D4281-3       | Spacer            | S090741        | ST084            | 1        |
| 004352         | S073828      | D4419-1       | Fwd Support Plate | S073827        | ST090            | 2        |
| 004352         | S091197      | MS20427M4-20  | Rivet             | f118429        | GA007            | 1        |
| 004352         | S091189      | MS20615-4M18  | Rivet             | s083540        | ST306            | 10       |
| 004352         | S091187      | MS21043-4     | Nut               | s062296        | ST302            | 2        |
| 004352         | S091186      | NAS1149C0432R | Washer            | s050052        | ST266            | 4        |

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/12/18 10:53 AM dart.quirion.sonia